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D350-591-133
Job Sheet 196461



Part No: D350-591-133

Job Qty: 10 pcs

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9712 REV A , IIN-D350-591 REV H , D2946 REV.C IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	7/29/19	7/29/19	0.00	6.96	Large Fab - 1		PLC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 5	10 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 10		DAS 43 9-09
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Large Fab - Welded Assy-2-B4B	10 pcs	7/29/19	7/29/19	0.00	6.96	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		

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					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	AUG 0 9 2019
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	DAS
					Large Fab - 6 - B4B	24
					Large Fab - 7 - B4B	9-89
					Large Fab - 8 - B4B	6102 5 0 90V
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
140 QC 9	10 pcs	7/29/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	DAS
					QC 9 - 43	43
					QC 9 - 50	9-89
					QC 9 - 9	
150 QC 5	10 pcs	7/29/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAS
					QC 5 - 49	43
					QC 5 - 51	9-89
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160 Handfinish - 1-1 Chemical- B4B	10 pcs	7/29/19	0.00 1.52		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	AUG 1 3 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170 QC 7	10 pcs	7/29/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	

					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	DAS 43
					QC 7 - 47	9-89
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
180	Large Fab - Welded Assy-3-B4B	10 pcs	7/29/19	0.00 6.96	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	DAS 24 9-89
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
190	QC 10	10 pcs	7/29/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	DAS 43
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
200	QC 5	10 pcs	7/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS 43
					QC 5 - 43	9-89
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

				QC 5 - 40	
210 Handfinish - 1-2- Chemical-B4B	10 pcs	7/29/19	0.00 1.52	Handfinish - 1 - 1 - B4B	BEB 19-08-15
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White GI(A)-B4B	10 pcs	7/29/19	0.00 1.04	Powdercoat - 1 - B4B	BEB 19-08-15
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk-B4B	10 pcs	7/29/19	0.00 1.25	Handfinish - 3 - 1 - B4B	M 19-8-15
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
240 QC 3	10 pcs	7/29/19	0.00 0.00	QC 3 - 10	DAS 81 9-89
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	7/29/19	0.00 0.00	Packaging 1 - 1 - B4B	AUG 15 2019
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	

				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	10 pcs	7/29/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	DAS
				QC 4 - 46	75
				QC 4 - 68	9-89
				QC 4 - 72	
				QC 4 - 74	8/1/2019
270 Packaging 3-1 - Stock - B4B	10 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	75
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	8/1/2019
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275	DC - 1 - B4B	10 pcs	7/29/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
280	QC 21 - FG	10 pcs	7/29/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill vent hole as per dwg
 Descriptions: using DT10462 and c'sink.

120 - QC5- Inspect part completeness to step on W/O

130 - (Weld per dwg A/R Aluminum rod Batch: 138872) Deburr and Bevel ends for welding Use DT8440 jig

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

180 - (Weld per dwg A/R Aluminum rod Batch: 138872) Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. 2- Install rivet in vent hole as per dwg

190 - (QC10- Inspect visual per QSI004- ground welds)

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Chemical Conversion Coat per QSI005 4.1)

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:45 TEMP: 375° F DWS 41:00

230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

240 - (QC3- Inspect Part Finish)

250 - (Pick Kit)

260 - (QC4- 100% Inspect kits for completeness)

270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038

275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

280 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	5 pcs (.5 ea)	110-Large Fab - Steps - 1	50203556
D2734	Step End Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5198347
D2944	Step Mounting Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5198436
MS20601-AD4W2	Rivet	10 Ea (1 ea)	180-Large Fab - Welded Assy-3- B4B	
AN4-11A	Bolt	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194816
AN4-16A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5193853
AN4-7A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5193826
D2230-1	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199732
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194067
D2732-030	Rubber Cushion - 3"	80 pcs (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5205050
D2945	Mounting Plate	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194489
D3338-1	Mounting Lug	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5123808
MS21042L4	Nut	140 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	5202688
NAS1149D0463J	Washer	140 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	5200189X56

5196202X84

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	5	22	0
130-Large Fab - Welded Assy-2- B4B	D2734	20	92	0
	D2944	20	49	0
180-Large Fab - Welded Assy-3- B4B	MS20601-AD4W2	10	236	0
250-Packaging 1-1 - Pick Kit - B4B	AN4-11A	40	270	0
	AN4-16A	80	1,031	0
	AN4-7A	20	150	0
	D2230-1	40	368	0
	D2230-3	40	740	0
	D2732-030	80	448	0
	D2945	10	58	0
	D3338-1	10	106	0
	MS21042L4	140	2,579	0
	NAS1149D0463J	140	4,772	0
Part Specifications				
Specifications could not be found.				

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DART
AEROSPACE

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Container No: S203557

Part: D350-591-133

Job No: 196461

Serial No/Batch: S203557

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1dairFA00/STC SH967NE 0

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>JS</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>JS</u>		
CHECKED	<u>GP</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT